Work Order I November-21-11 11			*767	772*						Page
Item ID: D32 Revision ID: Item Name: Dou	286-1 Ibler		Accept	*N900	040	100)* s	etup Start Stop	I	S1* S2*
Start Date: 21/3 Required Date: 10/0 Reference:	11/2011 Start Qty: 100. 01/2012 Req'd Qty: 100.	- • •		Cust Item I Customer:	D:				<u>-</u>	
Approvals: Pr	ocess Plan: M.L.T	Date: \\ \\\	て \ Tooling:	Da	ate:		R	tun Start	I <i>Z</i> I	R1*
	C:				ate:			Stop	*N	R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr				•					
D3286	Rev A									
100 *1\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\	FLOW WATER JET		0.00				18 II-	(1-24_		
FLOW CNC Waterjet ろみし、しょ	1-Cut as Dwg Rev Prog Rev								(10	3
110	QC2- Inspect parts of	machine FAI/FAIB	0.00							
110 QC Quality Control	Memo		0.00				1311-	-11-24		

120

120

Memo

QC8- Inspect parts - second check

0.00

0.00

Quality Control

Dart Aerospace Li	td
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W/O:			V	VORK ORDER CHAN	GES					
DATE	STEP	PROC	EDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									3	
										*,
Part No	•	PAR #:	_ Fault Ca	tegory:	NCR	: Yes	No DQ	A:	Date: _	
	Re	esolution:	_ Disposit	ion:	QA:	N/C Cld	sed:		Date: _	
NCR:		W	ORK OR	DER NON-CONFORM	IANCE	(NCR)			
DATE	STEP	Description of NC		·	ction B	0:	Verific		Approval	Approval
	JILF	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section	on C	Chief Eng	QC Inspector
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Work Orde November-21-11				*76	772*						Page 2
Item ID: Revision ID: Item Name:	D3286-1 Doubler		. A	Accept	*N900	<u>0</u> 40	100)*	Setup Sta	1 7	S1* S2*
Start Date: Required Date: Reference:	21/11/2011 10/01/2012	Start Qty: 100.00 Req'd Qty: 100.00	*100* *100*		Cust Item II Customer:) :		. ,			
Approvals:	Process Plan	n:	Date:	Tooling: SPC (Y/N):	Da	te:]	Run Sta , Sto	1/1	R _. 1* R2*
Sequence ID/ Work Center II 130 *130* Brake NC Brake NC		Operation Description NC BRAKE Memo Form as per D	lwg D3286	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* QC Quality Control		QC5- Inspect part complet Memo	eness to step on W/O	0.00		*		M		· /)	19 (
·	•		. ///			~ (·		

150

150 Packaging

Packaging

Identify as per dwg & Stock Location:

Memo

STOCK IN SKIDTUBE CELL

0.00

0.00

Dart Aerospace Ltd

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W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cat	egory:	_ NCR: Yes	No DQ	A:	Date: _	· · · · · ·
	R	esolution:	Dispositi	on:	_ QA: N/C C	losed:		Date:	
NCR:			WORK ORD	DER NON-CONFORMA	ANCE (NC	R)			
DATE	CTED	Description of NC	•		ion B	Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Secti		Chief Eng	QC Inspector
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Work Ord November-21-1				*767	772*							Page 3
Item ID: Revision ID: Item Name:	D3286-1 Doubler			Accept	*N900	040	100) *	Setup	Start Stop		S1* S2*
Start Date: Required Date: Reference:	21/11/2011 10/01/2012	Start Qty: 100.00 Req'd Qty: 100.00	=	00* 00*	Cust Item I Customer:	D:			_	5 44		
Approvals:	Process Pla	in:	Date:	Tooling: SPC (Y/N):		ate:				Start Stop		R1* R2*
Sequence ID/ Work Center II 160 *160*	D	Operation Description QC21- Final Inspection -	Work Order Releas	Set Up/ Run Hours se 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp

0.00

Memo

Quality Control

la 11.12.07

	Dart	Aer	OS	pace	Ltd
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W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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	-		 						
Part No		PAR #:			_ NCR: Yes	No DQ	A:	Date: _	
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NCR:		V	VORK ORI	DER NON-CONFORMA	ANCE (NCI	₹)			
DATE	STEP	Description of NC		Corrective Action Section		Verifi	cation	Approval	Approval
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Picklist Print

November-21-11 11:07:33 AM

Work Order ID: 76772

76772

Parent Item:

D3286-1

D3286-1

Parent Item Name: Doubler

Start Date: 21/11/2011

Required Date: 10/01/2012

Page 1

Start Qty: 100.00

Required Qty: 100.00

Comments:

IPP A04.07.14New issueKJ/JLM

Now on Waterjet 06-06-16 JLM IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No			100	sf	93.3000	0.0749	7.884211	9,		
M304S11	IGA								**		311-11-24	t	

304/316 0.125 Sheet

Location Loc Qty Loc Code MAT020 93.3 119006 41.5 119048 51.8

Dart Aerospace Ltd

W/O:		·	V	ORK ORDER CHANG	ES			
DATE	STEP	PRO	CEDURE CH	IANGE	Ву	Date 0	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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		·						
	:	·						
Part No	•	PAR #:			NCR: Yes	No DQA:	Date: _	
	R	esolution:	Disposit	ion:	_ QA: N/C C	losed:	Date: _	
NCR:		V	VORK ORI	DER NON-CONFORMA	ANCE (NC	R)	,	
DATE	STEP	Description of NC		Corrective Action Section		Verificati	ion Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Section (QC Inspector
 								
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DART AEROSPACE LTD	Work Order:	76772
Description: Doubler	Part Number:	D3286-1
Inspection Dwg: D3286 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	riko i	ARTICLE	NOPEC II	ON CHI	ECKLIST	
	X	First Arti	cle _	Prot	otype	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.374	+/-0.010	5.38(7		V 1362	
3.974	+/-0.010	3,970	7		V	
2.000	+/-0.010	7,000	7		V	
1.000	+/-0.010	1,010	> .		V	
0.700	+/-0.010	.697	8		V	
Ø0.188	+0.005/-0.001	(190	2		V	
0.125	+/-0.010	1121	2		V	
	B	Audited by:	1.4 1 147		Prototype Approv	
Date:	11-11-24	Date:	17.11	28	Da	te: N/A

Rev	Date	Change	Revised by	Approved
Α	06.11.07	New Issue	KJ/JLM ox	B
			7.0	

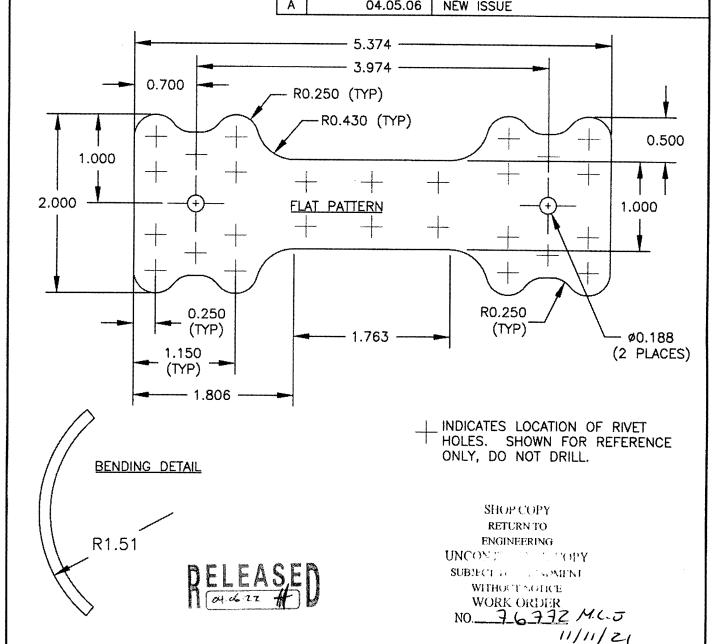
Dart Aerospace Ltd

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W/O:			WC	RK ORDER CHANG	GES							
DATE	STEP	PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
					-							
Part No	:	PAR #:	Fault Cate	gory:	NCR	: Yes	No DQ	A:	Date:			
Resolution:			Disposition	Disposition: QA				QA: N/C Closed: Date:				
NCR:			WORK ORDI	ER NON-CONFORM	ANCE	(NCR)					
DATE	STEP	STED Description of NC		Corrective Action Section B Initial Action Description			Verific		Approval	Approval		
	Section A		Chief Eng	Action Description Chief Eng		Sign & Se		on °C	Chief Eng	QC Inspector		
							:					





DES	ign A	DRAWN BY	DART	AEROSI PORT H	PACE ADLOCK, V		IN	C.	
CHE	CKED.	APPROVED	DRAWING NO. D3286		····	SHE	ET 1	REV. OF	
DAT	• •	***************************************	TITLE					SCA	TE.
04	.05.06		GROUND	HANDLING	PARTS				1:1
Ι Δ		04.05.06	NEW ICCI	10					-



D3286-1 DOUBLER

1) MATERIAL: AISI 304/316 SS SHEET 0.125" THICK (REF DART SPEC. M304S11GA)

2) BREAK ALL SHARP EDGES 0.010 TO 0.020

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) ALL DIMENSIONS ARE IN INCHES

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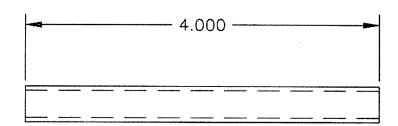
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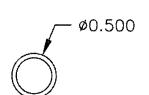
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W/O:			W	ORK ORDER CHANG	GES						
DATE	STEP	PROCEDURE CHANGE			В	/	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No		PAR #:	Fault Cate	gory:	NCR: Y	es N	lo DQ	A:	Date:		
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NCR:			WORK ORD	ER NON-CONFORM	ANCE (N	CR)					
DATE	STEP	Description of NC	Corrective Action Section				Verification		Approval	Approval	
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		gn & ate	Secti	on C Chi	Chief Eng	QC Inspector	
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DESIGN	DRAWN BY	DART	AEROSPACE PORT HADLOCK, W	
CHECKED;	APPROVED,	DRAWING NO.		REV. A
#-	#t	D3286		SHEET 2 OF 2
DATE		TITLE		SCALE
04.05.06		GROUND	HANDLING PARTS	1:1





D3286-3 SPACER

- 1) MATERIAL: AISI 304/316 SS TUBING, 0.500 O.D. x 0.049 WALL (REF DART SPEC. M304TR0.500W.049)
- 2) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES



Dart Aerospace	Ltd
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W/O:			V	ORK ORE	DER CHAN	GES					`.
DATE	STEP	PRO	CEDURE CH	IANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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DATE	STEP	Description of NC Section A	Initial	Corrective Actio	n Description	ction B	Sign &	Verific Section		Approval Chief Eng	Approval QC Inspector
			Chief Eng		Chief Eng		Date				
				·							